

Vydyne® PF004

polyamide 6



Vydyne PF004 is a 20% glass filled PA6 for injection molded applications.

General				
Regional Availability	• North America	• Europe		
Additive	• Release agent			
Features	• Good Stiffness	• Good Strength		
Agency Rating	• ISO, 1043 PA6 GF20	• ISO, 1043 PA6 GF20		
Appearance	• Natural Color			
Forms	• Pellets			
Processing Method	• Injection Molding			

Physical	dry	cond.	Unit	Test Standard
Density	1.27	-	g/cm ³	ISO 1183

Mechanical	dry	cond.	Unit	Test Standard
Tensile Modulus (23°C)	6200	-	MPa	ISO 527-2
Tensile Stress (Yield, 23°C)	106	-	MPa	ISO 527-2
Tensile Strain (Yield, 23°C)	3	-	%	ISO 527-2
Flexural Modulus (23°C)	4600	-	MPa	ISO 178
Flexural Strength (23°C)	158	-	MPa	ISO 178

Impact	dry	cond.	Unit	Test Standard
Notched Izod Impact Strength, +23°C	7	-	kJ/m ²	ISO 180/1A
Unnotched Izod Impact Strength, +23°C	40	-	kJ/m ²	ISO 180/1U

Thermal	dry	cond.	Unit	Test Standard
Heat Deflection Temperature, 1.80 MPa, Unannealed	165	-	°C	ISO 75-2/A

Injection	Value	Unit
Drying Temperature	80	°C
Drying Time	4	h
Suggested Max Moisture	0.2	%
Rear Temperature	230 - 240	°C
Middle Temperature	240 - 250	°C
Front Temperature	240 - 270	°C
Processing (Melt) Temperature	240 - 270	°C
Mold Temperature	60 - 80	°C

